

Ship Feb 27

Work Order ID 129494

129494

Page 1

Thursday, February 12, 2015 9:15:55 AM

Item ID: D3805-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Run-on Landing Wearplate Fwd
 Start Date: 2/13/15 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 2/26/15 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan:  Date: 15-2-12 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3805	C								

100

0.00

100

Large Fab

Large Fab

Memo

0.00

1- On D3806-1, fill cut outs with hardcoat welding rod as per dwg D3805
 2059 B Hardcoat Welding Rod
 BATCH#: M131289

2-weld D3806-1 to D3805-1 together as per dwg D3805
 304 S.S. Welding Rod
 BATCH #: M126048

3-Transfer drill holes in bar

20 15-02-25 MAL

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Quality Control

Memo

0.00

20 15-2-25 DAS 50 9:89

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Item ID: D3805-041 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 2/26/15 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120						(20)			EB
QC	Memo	0.00							15-02-25
Quality Control									
150		0.00							
150						20			ENB-02-28
Small Fab	Memo	0.00							
Small Fab	1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 dwg D3805. TEXTURED COATING B#: 131451								
160	QC5- Inspect part completeness to step on W/O	0.00							
160						(20)			DAS
QC	Memo	0.00							38
Quality Control									9-89

FEB 26 2015

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Page 3

Item ID: D3805-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Run-on Landing Wearplate Fwd
 Start Date: 2/13/15 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 2/26/15 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <i>Flax</i>	0.00							
170						20			68-6
Packaging	Memo	0.00							90
Packaging									DAS
								FEB 26 2015	
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

mcj 15-02-26
ME
15-2-26

Picklist Print

Thursday, February 12, 2015 9:15:59 AM

Page 1

Work Order ID: 129494

129494

Parent Item: D3805-041

D3805-041

Parent Item Name: Run-on Landing Wearplate Fwd

Start Date: 2/13/15

Required Date: 2/26/15

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:EC IPP Rev:B 09-03-04 rev.a as per dwg DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC IPP REV:D 14.04.22 DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3805-1		Manufactured	No			100	Each	12.0000	1	20			

D3805-1

Plate

B 129497 x 8

Location

Loc Qty

Loc Code

WA001

12

124457 x 1

1

127088 x 9

9

96007 x 2

2

x20

15-02-25 MAL

D3806-1

Manufactured No

100

Each

6.0000

1

20

D3806-1

Bar

B 129911 x 8

Location

Loc Qty

Loc Code

WA001

6

91201 x 6

6

x20

15-02-25 MAL

B 129498 x 6

8

7

6

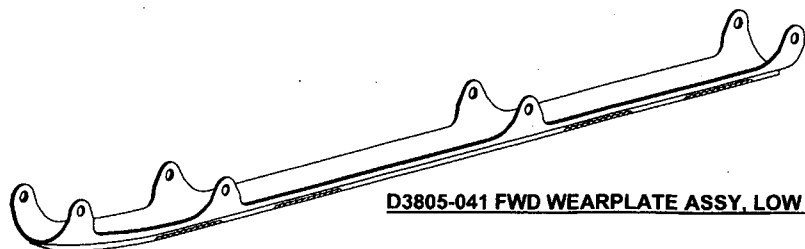
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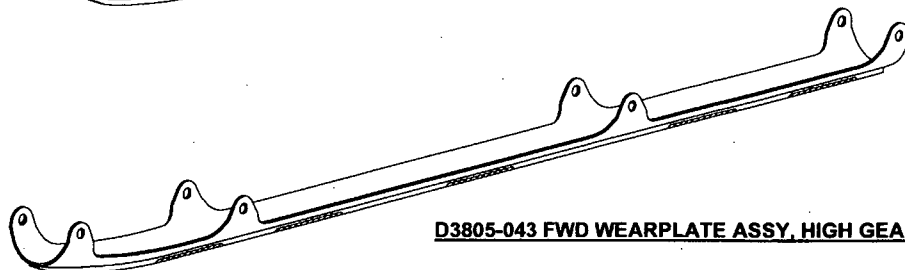
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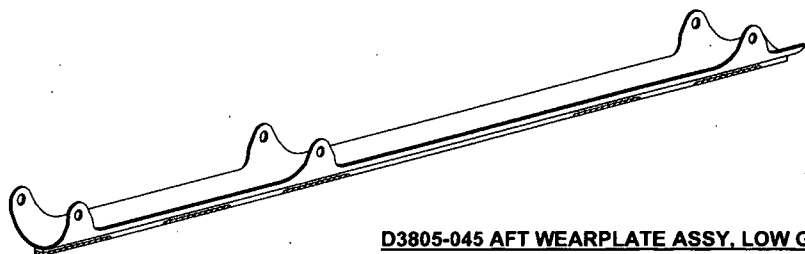
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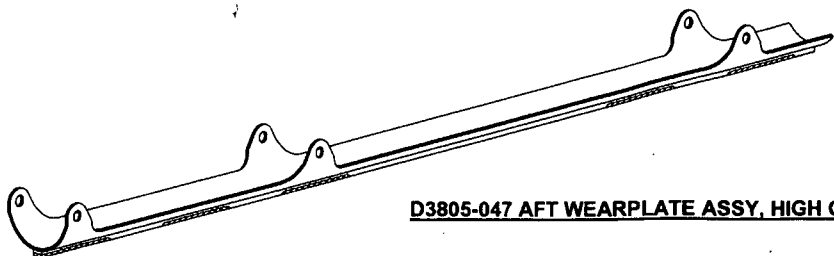
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



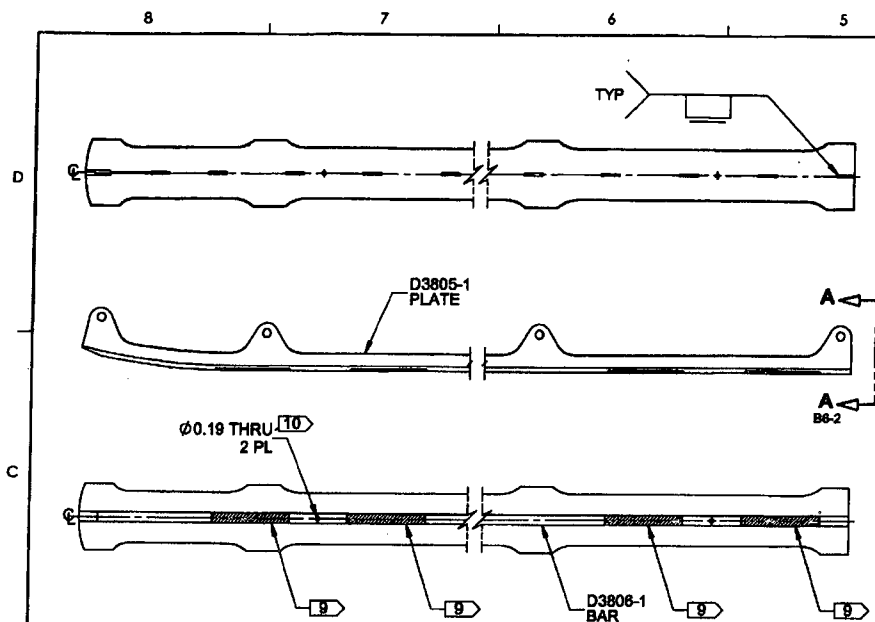
D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT

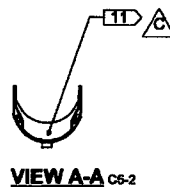
RELEASED
2014-04-17

C	REMOVE ITEMS 19, 20, 21, 22 AND 32 FROM BOM (ZN C4-1). REVISE NOTE 11, SHEETS 2&3 (ZN A8-2, B2-2, B6-2, A8-3, B2-3, B6-3)	DB	13.10.04
B	REVISED D3805-1F1-3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PAR11-106) AND RE-ORGANIZED NOTES SHEETS 2 & 3	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV	DESCRIPTION	BY	DATE
DESIGN	q	DB	
DRAWN	DB		
CHECKED	ASS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.10.04		
DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D3805 TITLE WEARPLATE ASSY REV. C SHEET 1 OF 8 SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

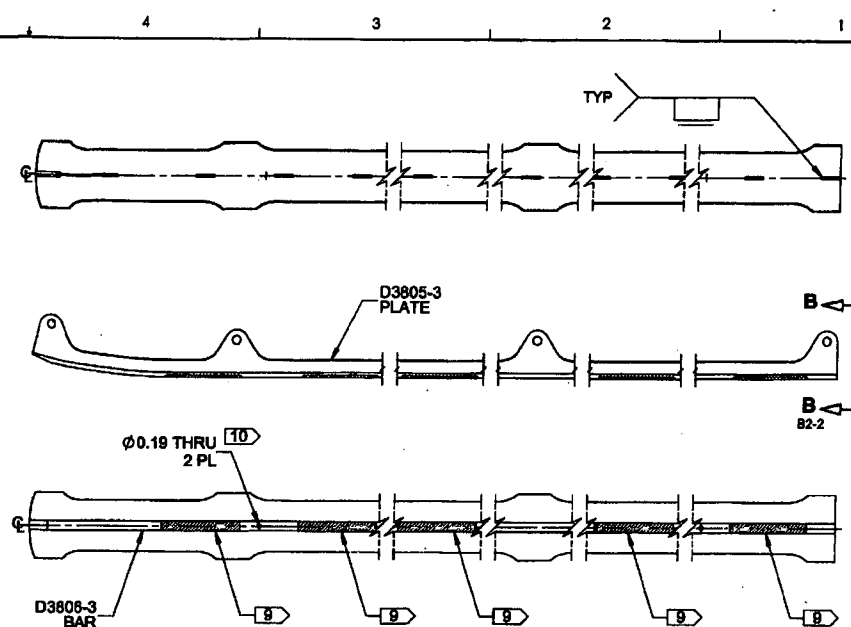
D52-12
129494



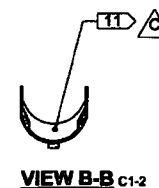
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



VIEW A-A C6-2



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



VIEW B-B C1-2

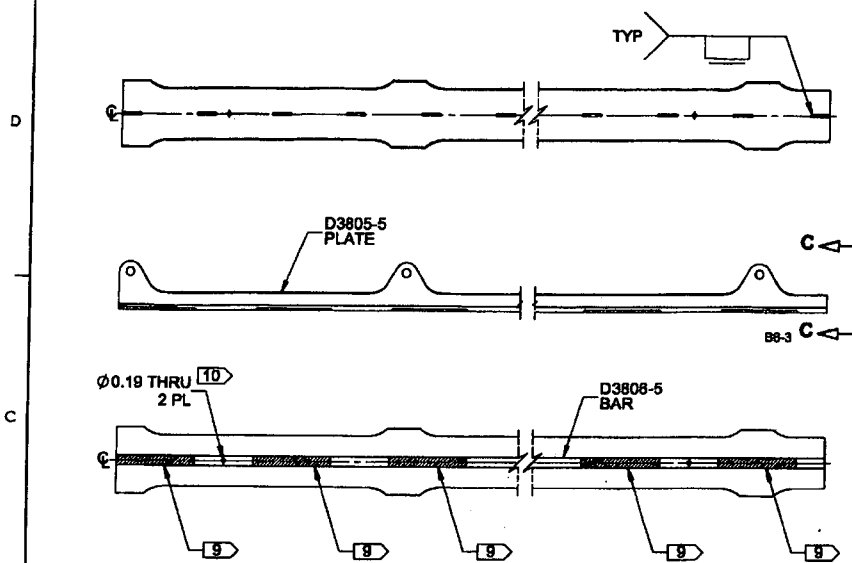
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2014-04-17
N/A

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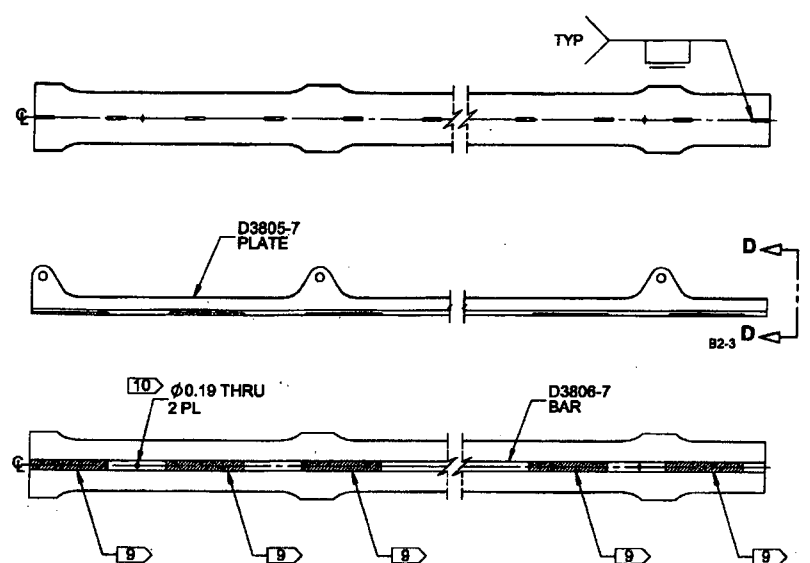
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	DS	D3805	SHEET 2 OF 8
APPROVED	MS	TITLE	SCALE
DE APPR.	SH	WEARPLATE ASSY	NTS
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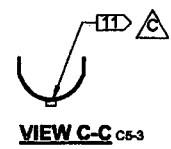
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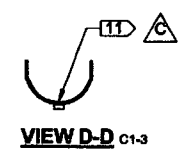
D3805-045 AFT WEARPLATE ASSY.



D3805-047 AFT WEARPLATE ASSY.



VIEW C-C C5-3



VIEW D-D C1-3

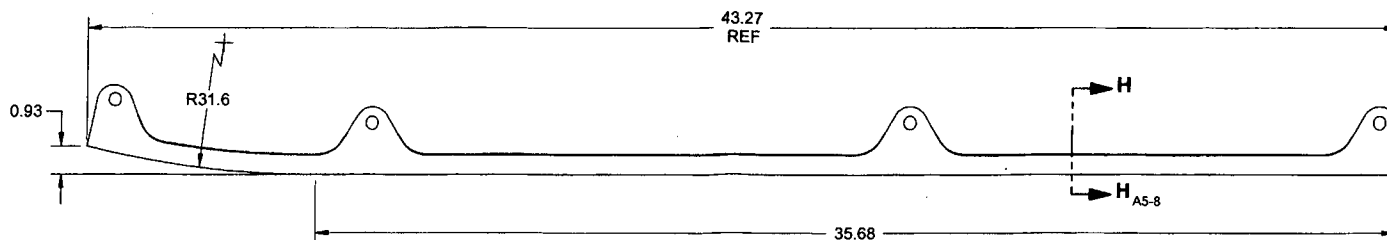
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2014-04-17

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2058B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
 - 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.

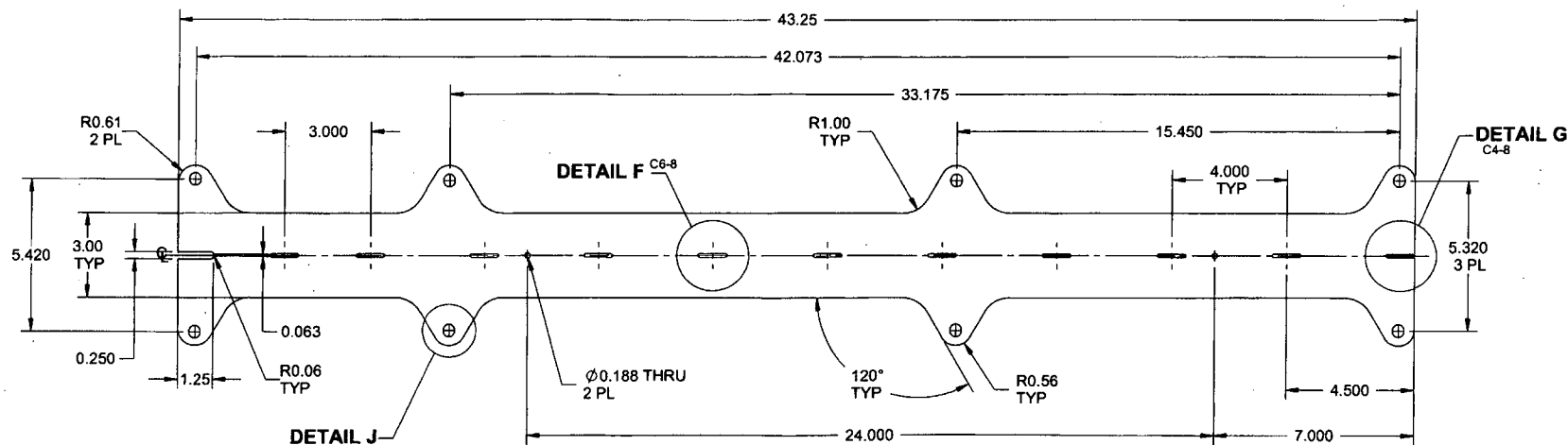
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MFG. APPR.	ALS	D3805	SHEET 3 OF 8
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D3805-1 PLATE
(MAKE FROM D3805-1F)



D3805-1F PLATE

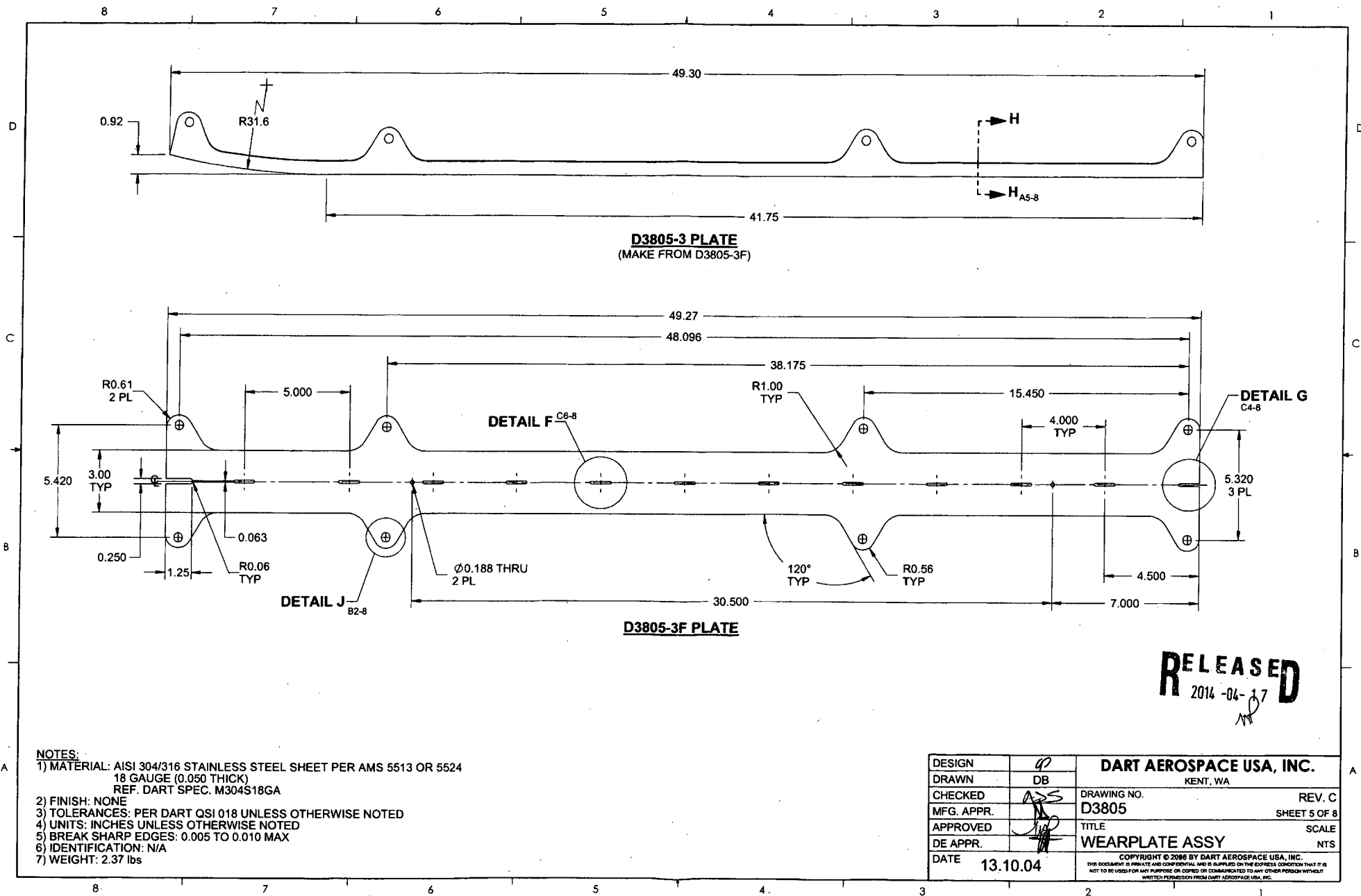
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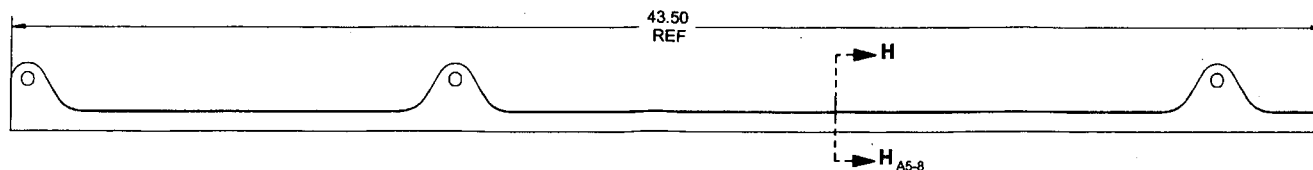
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.11 lbs

DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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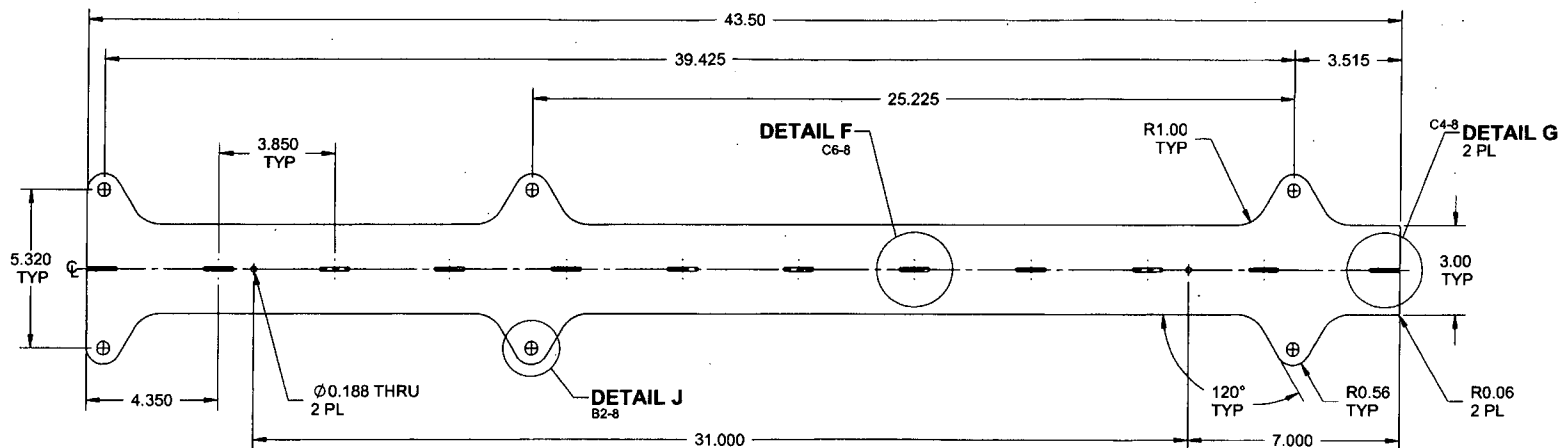
8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



D3805-5 PLATE
(MAKE FROM D3805-5F)



D3805-5F PLATE

RELEASED
2014-04-17

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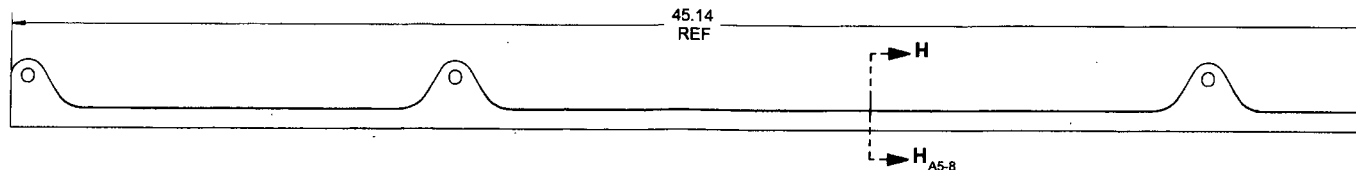
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REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

DESIGN	DP	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	JP	D3805	SHEET 6 OF 8
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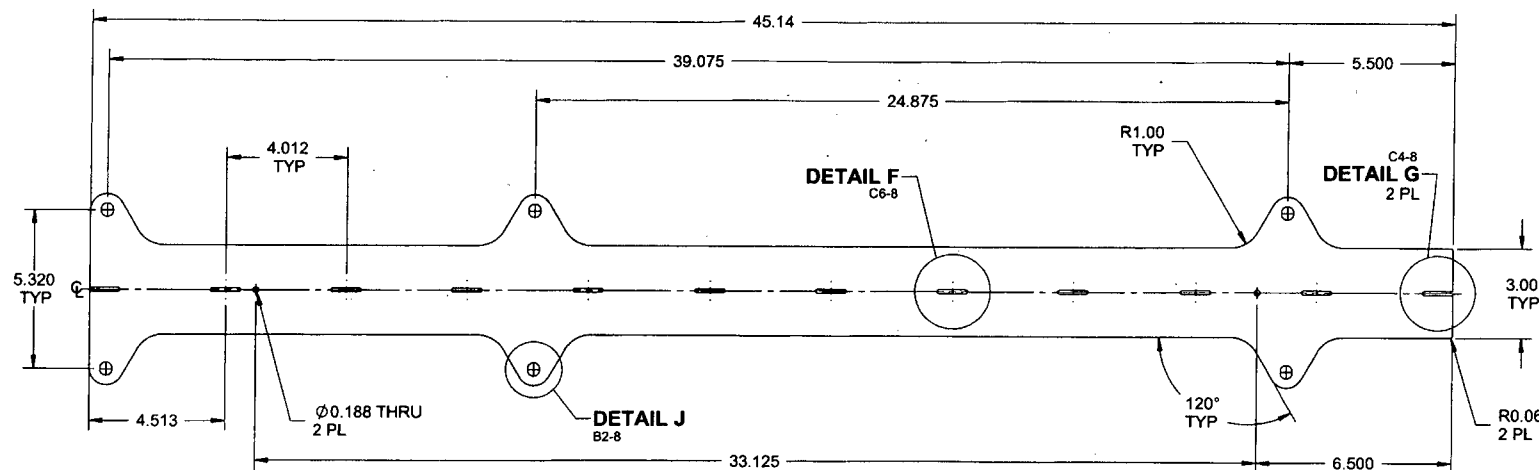
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D



D3805-7 PLATE
(MAKE FROM D3805-7F)

C



D3805-7F PLATE

RELEASED
2014-04-17

NOTES:

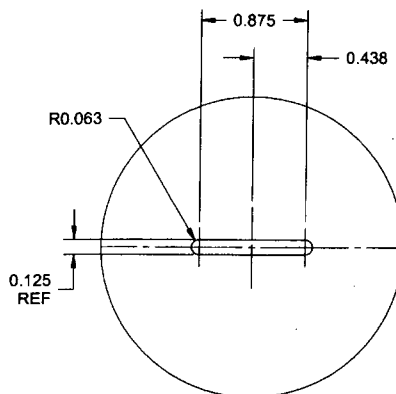
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18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 7 OF 8
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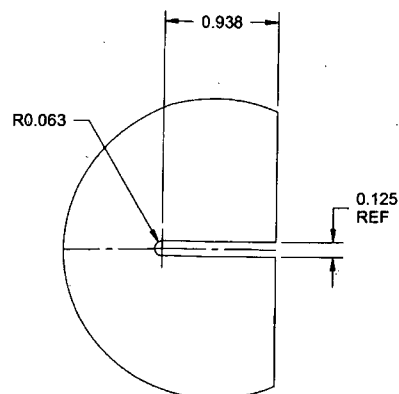
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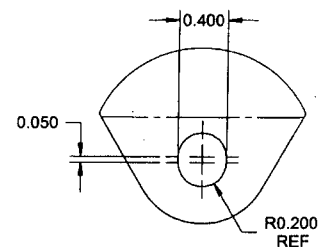
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



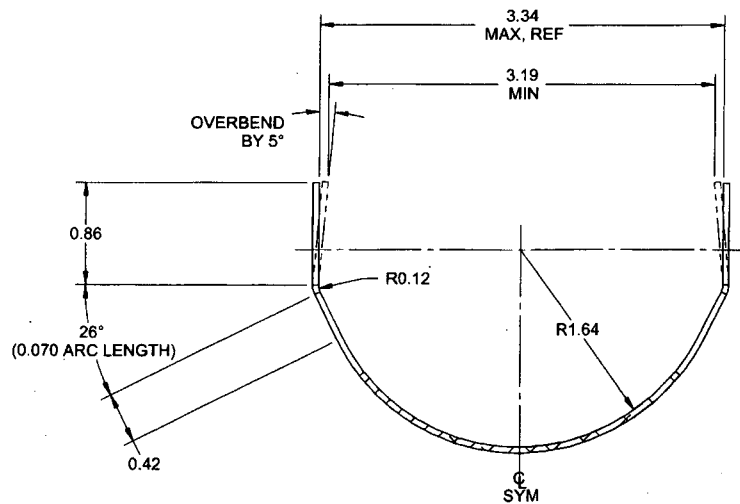
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

RELEASED
2014-04-10

DESIGN	DB	DART AEROSPACE USA, INC.	
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CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 8 OF 8
APPROVED		TITLE	SCALE
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